

Work Order ID 57956

April 21, 2010 8:45:01 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: PL

Date: 10-4-21

Tooling:

Date: ;

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3929

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

RB 10-4-26

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 10-4-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 57956

April 21, 2010 8:45:01 AM



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| | | | | | |
|----------------------------|-----------------|--|---------------|-------|--|
| Item ID: D3929-042 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Gusset Assembly | | | | | |
| Start Date: 21/04/2010 | Start Qty: 6.00 | | Cust Item ID: | | |
| Required Date: 28/04/2010 | Req'd Qty: 6.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |
| 130 | Pick Kit | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| Large Fab Large Fab | Memo | 0.00 | | | | | | | |
| | Weld bushings D3907-1 as per dwg D3929 | | | | | | | | |
| | 316L rod batch: 111679 | | | | | | | | |

N/A

Pl 10.04.28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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April 21, 2010 8:45:01 AM



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Revision ID:

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Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

⑥ 10-04-29

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⑥

-042

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD
10-04-29

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 57956

April 21, 2010 8:45:01 AM



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Item ID: D3929-042

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Stop



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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30
MF
10-4-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:45:05 AM

Page 1

Work Order ID: 57956

Parent Item: D3929-042

Parent Item Name: Gusset Assembly

Comments:

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M304S11GA

Purchased

No

100

sf

14.2200

2.8421



304/316 0.125 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT19

14.22

112663

14.22

D3907-1

Manufactured

No

130

Each

31.0000

12.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

31

57242

31

B 10-4-26

(6)

112663

Apr 10.04.28

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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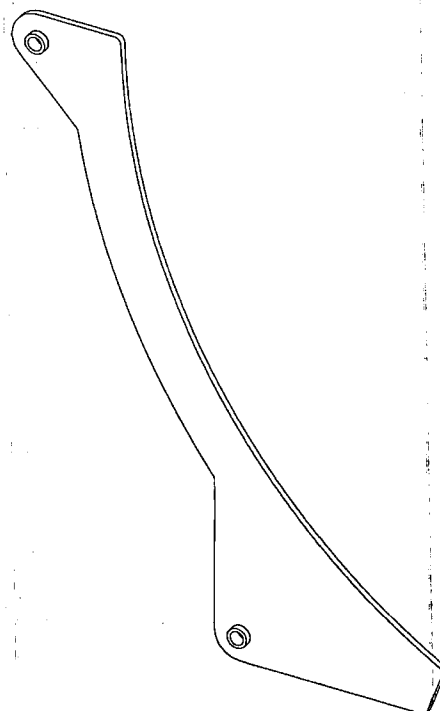
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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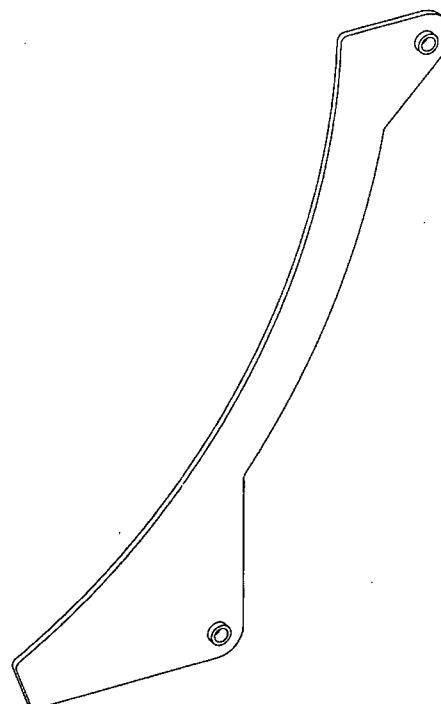
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|-----------------|
| 1 | X | | D3929-041 | GUSSET ASSEMBLY |
| 2 | | X | D3929-042 | GUSSET ASSEMBLY |
| 11 | 2 | 2 | D3907-1 | BUSHING |
| 12 | 1 | 1 | D3929-1 | SUPPORT GUSSET |



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57954

BJ 10-4-21

RELEASED
8/6/42

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 09.04.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.04.03 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929**
REV. A
SHEET 1 OF 3

TITLE **GUSSET ASSEMBLY**
SCALE
NTS

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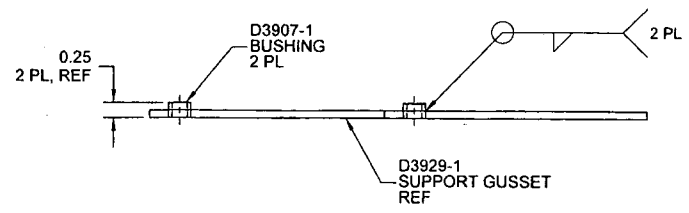
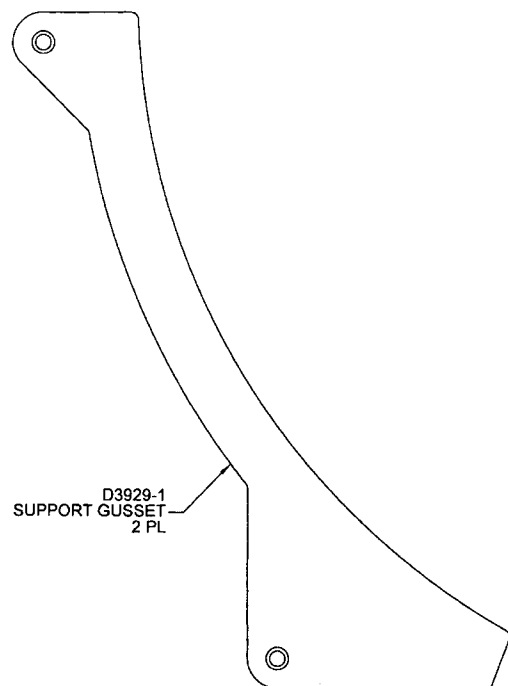
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

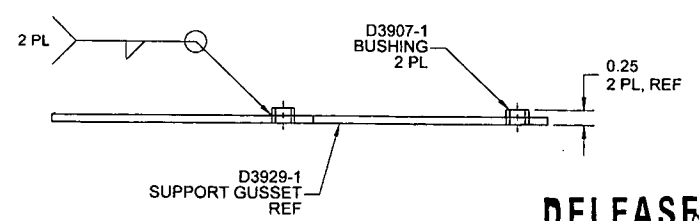
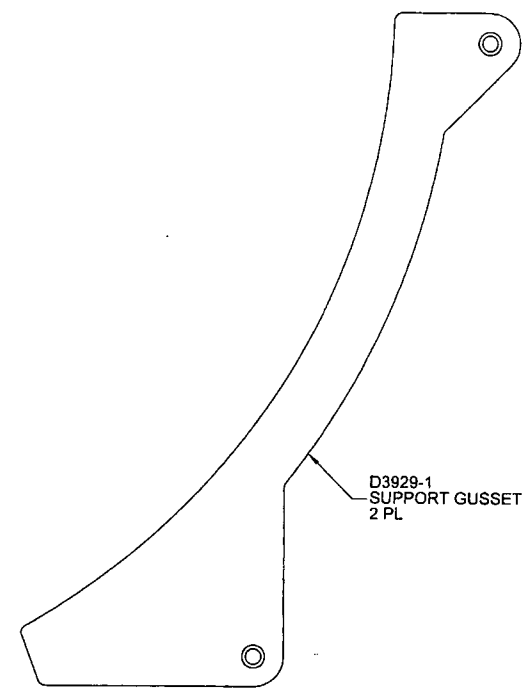
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| | | | | | | | | |
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NOTE: Date & initial all entries



D3929-041 GUSSET ASSEMBLY

w/057954



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3929 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUSSET ASSEMBLY | NTS |
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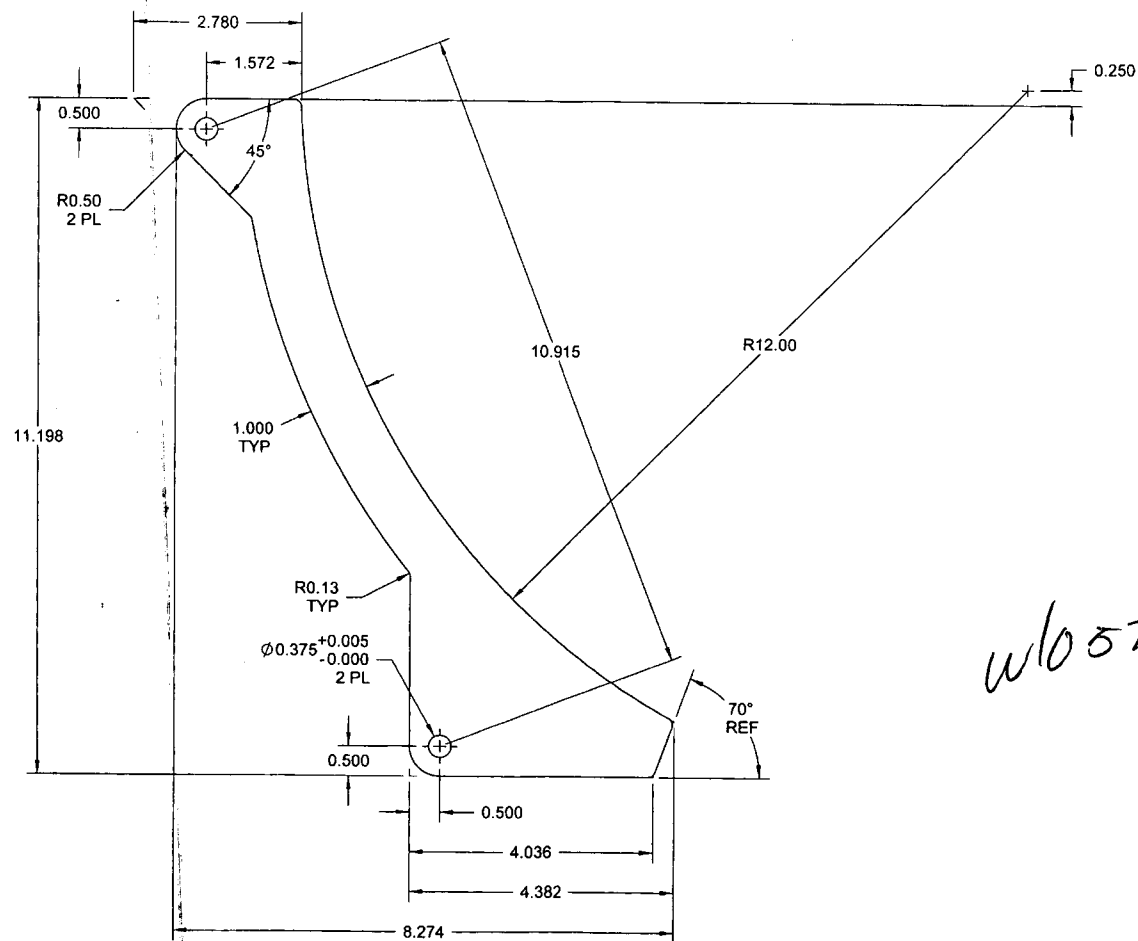
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| | | | | | | | | |

NOTE: Date & initial all entries



D3929-1 SUPPORT GUSSET

W/057954

RELEASED
07/04/22-11/03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

| | | | |
|---|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3929 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
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